

Work Order ID 54763

December 21, 2009 9:06:06 AM

Page 1

Item ID: D2562-001

Accept

Revision ID:

Item Name: Strut

Start Date: 12/21/09 Start Qty: 6.00

Required Date: 1/04/10 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2562

Rev D

100

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Punch to length as per Dwg D2562

M.D. 10/01/15

6X

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- Bend end as per Dwg D2562 Angle "D" 12-Debur

M.D. 10/01/15

6X

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

⇒ 8/10/18

46

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Page 2

Item ID: D2562-001

Accept



Setup Start



Revision ID:

Item Name: Strut

Stop



Start Date: 12/21/09 Start Qty: 6.00



Cust Item ID:

Required Date: 1/04/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

2:30pm

FINISH TIME:

OVEN TEMPERATURE:

300°F

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: 264

0.00



Packaging

Memo

0.00

Packaging

10-1-20 62 SP

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Item ID: D2562-001

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Setup Start



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Stop



Start Date: 12/21/09 Start Qty: 6.00



Cust Item ID:

Required Date: 1/04/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/2010
MF 10-1-20

Picklist Print

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1

Work Order ID: 54763

Parent Item: D2562-001

Parent Item Name: Strut



Comments:

Start Date: 12/21/09

Required Date: 1/04/10

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.500W.035 		Purchased	No			100	f	202.7814	10.7792			
												
304 RD Tube .500 x .035W												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	202.7813674	
108250	2.23	
111704	31.6682737	
112187	43.9830937	
112800 ✓	124.9	

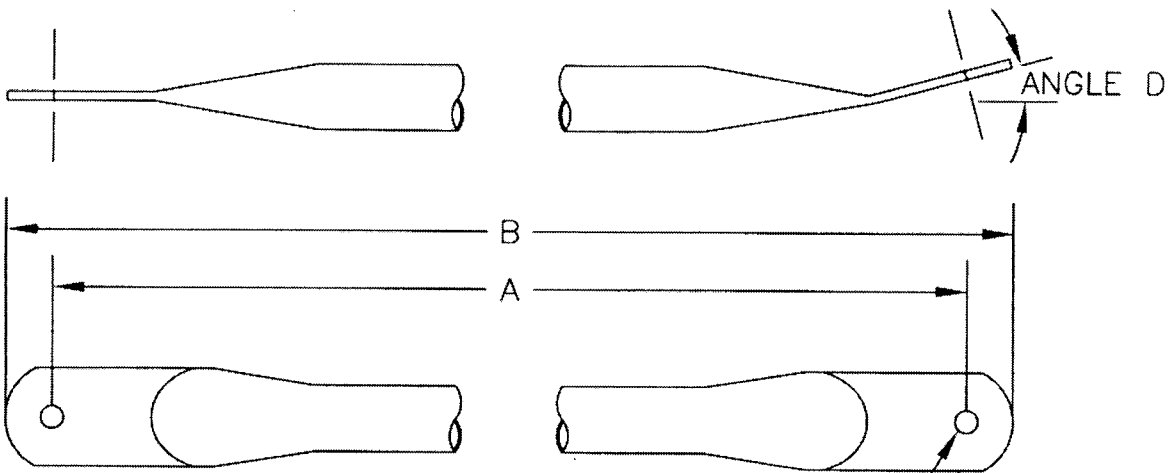
M.H.
10/01/14
10-7792

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CP	RF	HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
<i>[Signature]</i>	<i>[Signature]</i>	D2562	SHEET 1 OF 1
DATE	TITLE	SCALE	
05.05.18	STRUT	1:2	

A	96.05.01	NEW ISSUE
B	98.10.15	UPDATED MATERIAL NOTE (TSR A603)
C	02.06.05	ADD -005; ADD FINISH
D	05.05.18	ADD -007/-011/-013; UPDATE -005

W/D 54963



"C" DIA TO BE OPENED MANUALLY
PUNCH ENDS PER SPEC CONTROL DRAWING D2727

PART #	DIM A	DIM B	DIA C	ANG D
D2562-001	19.68	20.48	-	10
D2562-003	20.37	21.17	-	18
D2562-005	29.00	29.80	-	30
D2562-007	19.22	20.02	-	0
D2562-011	25.79	26.59	-	16
D2562-013	26.63	27.43	-	24

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TR0.500W.035) ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

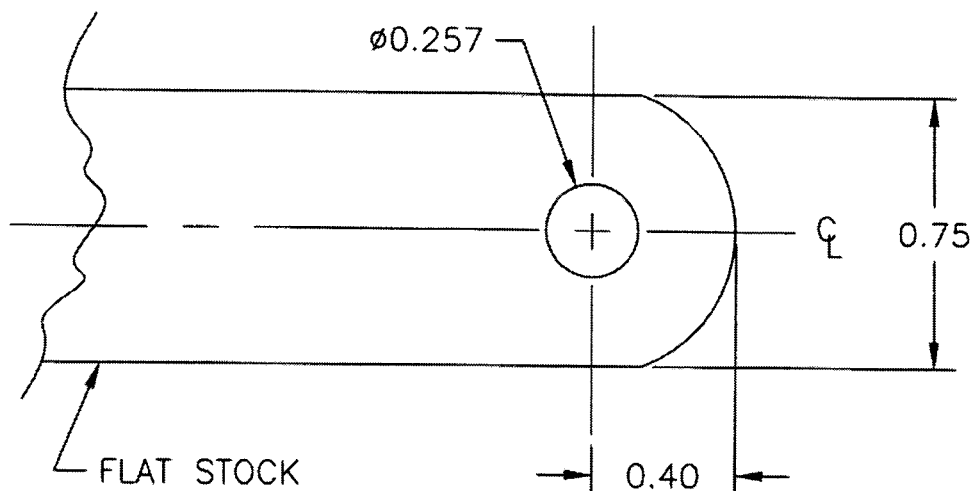
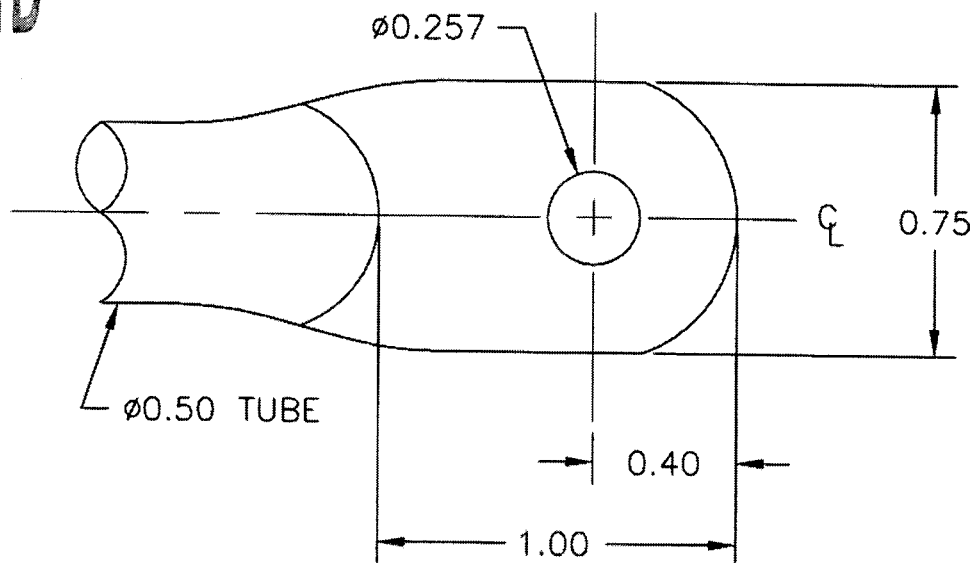


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2727	REV. A SHEET 1 OF 1
DATE 97.11.24		TITLE PUNCH DT8012 SPEC CONTROL	SCALE 2:1
A	97.11.24	NEW ISSUE	
A1	<i>#1P</i> 01.12.20	ADD TOLERANCE NOTE	

SPECIFICATION CONTROL DRAWING
FOR PUNCH DT8012

RELEASED
98/03/06 KE

54763



NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

